

[54] **GLASS LEHR ROLL AND METHOD OF MANUFACTURE**

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[51] **Int. Cl.** **B21b 31/08**

[58] **Field of Search** 29/132, 131, 129.5, 110, 29/125; 65/374, 348, 104; 15/98, 209.5, 209 A, 230, 230.12, 230.19

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[57] **ABSTRACT**

A construction and method of manufacture for flat glass annealing lehr rolls having a metal body and a covering of insulating material made from glass, ceramic or metallic fibers. Among the glass and ceramic fibers are amorphous silica, amorphous graphite, ceramic fibers such as "Kaowool" or "Fiberfrax," quartz or mineral wool, metallic fibers, fibermetal or porous metal might be carbon steel, stainless steel or other metals, or alloys such as nickel or bronze. The covering is a temperature-resistant material which is flexible and resilient at lehr temperatures and has a relatively low radial coefficient of thermal conductivity. The covering is relatively thin in most embodiments of the invention, and may be slipped on as a sleeve or applied and secured in other ways.

24 Claims, 19 Drawing Figures

